

# Work Order ID 86437

June-28-12 1:03:54 PM

**\*86437\***

Page 1

Item ID: D2739

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: 350 I Beam

Start Date: 28/06/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 12/07/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/20 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: 12/06/20 SPC (Y/N):

Date:

Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description   | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr                       | Revision Nbr   |                      |         |        |              |               |               |                  |                |
| D2739                          | Rev E  |                      |         |        |              |               |               |                  |                |
| 100                            |  | 0.00                 |         |        |              |               |               |                  |                |
| <b>*100*</b>                   | Skidtubes  |                      |         |        |              |               |               |                  |                |
| Skidtubes                      | Memo   | 0.00                 |         |        |              |               |               |                  |                |
| Skidtubes                      | 1-Cut D2600-5 to length as per Dwg D2739.<br>2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739.<br>3-Use uni-bit to open holes to finish size as per Dwg D2739.<br>4-Bevel Fwd end of extrusion and Deburr holes and ends.<br>5-Deburr |                      |         |        |              |               |               |                  |                |
| 120                            | Chemical Conversion Coat per QSI005 4.1  | 0.00                 |         |        |              |               |               |                  |                |
| <b>*120*</b>                   | HandFinish   |                      |         |        |              |               |               |                  |                |
| Hand Finishing                 | Memo   | 0.00                 |         |        |              |               |               |                  |                |



B 12/07/18

OC 12/07/18

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 86437

June-28-12 1:03:54 PM

**\*86437\***

Page 2

Item ID: D2739

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: 350 l Beam

Stop **\*NS2\***

Start Date: 28/06/2012 Start Qty: 4.00 **\*4\***

Cust Item ID:

Required Date: 12/07/2012 Req'd Qty: 4.00 **\*4\***

Customer:

Reference:

|            |               |       |            |       |                        |
|------------|---------------|-------|------------|-------|------------------------|
| Approvals: | Process Plan: | Date: | Tooling:   | Date: | Run Start <b>*NR1*</b> |
|            | QC:           | Date: | SPC (Y/N): | Date: | Stop <b>*NR2*</b>      |

| Sequence ID/<br>Work Center ID                | Operation<br>Description                                    | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|---|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130<br><b>*130*</b><br>QC<br>Quality Control  | QC5- Inspect part completeness to step on W/O<br><br>Memo   | 0.00<br><br>0.00     |         |        |              |               |               |                  |                |
| 140<br><b>*140*</b><br>Packaging<br>Packaging | Identify as per dwg & Stock Location: <u>LG</u><br><br>Memo | 0.00<br><br>0.00     |         |        |              |               |               |                  |                |
| 150<br><b>*150*</b><br>QC<br>Quality Control  | QC21- Final Inspection - Work Order Release<br><br>Memo     | 0.00<br><br>0.00     |         |        |              |               |               |                  |                |

DAS  
03  
2.8

DP

12-7-18

12/07/18

4

12/7/20

ME  
12-07-20

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

June-28-12 1:03:57 PM

Page 1

Work Order ID: 86437

\*86437\*

Parent Item: D2739

\*D2739\*

Parent Item Name: 350 I Beam

Start Date: 28/06/2012

Required Date: 12/07/2012

Start Qty: 4.00

Required Qty: 4.00

## Comments:

IPP Rev: C02.11.28ReformatKJ

IPP Rev: D 06-03-21 As Per Rev C JLM

IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev:F

10.11.02 as per revE DD verf:EC

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D2600-5-108

Manufactured

No

100

Each

104.0000

1

4

\*D2600-5-108\*

Extrusion 'I' Beam' thin

\*\*

4

312/07/18

## Location

## Loc Qty

## Loc Code

LG

104

47814

20

73909

84

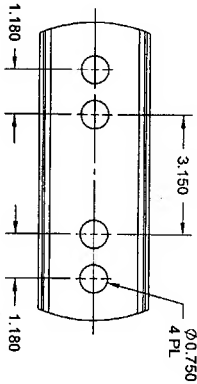
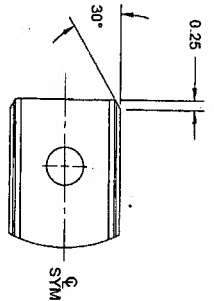
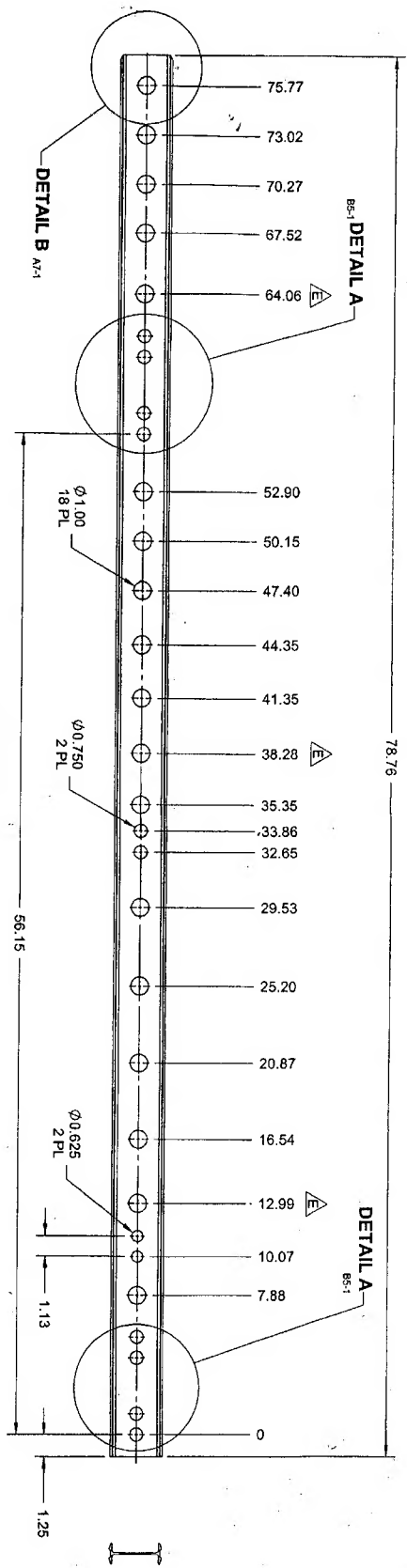
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



- NOTES:
- 1) MATERIAL: MAKE FROM D2800-5 EXTRUSION
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK: SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: DART P/N D2739 AND BIN PER DART QSI 044 6.1
  - 7) WEIGHT: 3.41 LBS

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 26437 MLC  
12/30/28

|      |  |    |          |
|------|--|----|----------|
| REV. | DESCRIPTION                                    | BY | DATE     |
| A    | NEW ISSUE                                      | DS | 98.04.16 |
| B    | CHANGE HOLES FOR COMPATIBILITY WITH AIRCRAFTER | CP | 98.11.18 |
| C    | ADD BEVEL TO FWD END; ADD DETAIL B             | PH | 06.01.05 |
| D    | ADD BEVEL TO FWD END; ADD DETAIL B             | CP | 07.05.29 |
| E    | ADD BEVEL TO FWD END; ADD DETAIL B             | CP | 10.10.08 |

|           |          |                          |
|-----------|----------|--------------------------|
| DESIGN    | DS       | DART AEROSPACE USA, INC. |
| DRAWN     | DS       | PORT HADLOCK, WA         |
| CHECKED   | DS       |                          |
| MFG. APPR | DS       |                          |
| APPROVED  | DS       |                          |
| DATE      | 10.10.08 |                          |

|             |       |              |
|-------------|-------|--------------|
| DRAWING NO. | D2739 | REV. E       |
| TITLE       | WEB   | SHEET 1 OF 1 |
| SCALE       | NIS   |              |

RELEASED  
R 2010-11-01

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries